

Work Order ID 83809

83809

Page 1

Item ID: D4095-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearplate Assembly

Stop *NS2*

Start Date: 26/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/26

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4095

B

(9)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-1)

304.063

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B12-5-1

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-5-1

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Scrubbing

(19)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 83809

April-26-12 12:39:45 PM

83809

Page 2

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N900040100Setup Start ***NS1***

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1- bend section C-C first
2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

(9)

26/05/09

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D4095

8/12/09

(x9)

150

Weld per dwg A/R Hardcoat S.S. Batch

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

M122030

9

12-06-20

JBL/MAL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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April-26-12 12:39:45 PM

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Required Date: 10/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 9X | | | Cpl 12.06.20 |
| Quality Control | | | | | | | | | |
| 170 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 9 | | | W 12.06.21 |
| Quality Control | | | | | | | | | |
| 180 | | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | AB | | | 12 - 6 - 21 ⑨ |
| Hand Finishing | COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 121960 | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

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N900040100

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Revision ID:

Stop *NS2*

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Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

9x

12/06/22

200

Identify as per dwg & Stock Location: FP

0.00

200

Packaging

Memo

0.00

Packaging

9x

54P 85 726 74

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCJ 12/06/22

MCJ 12/06/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

April-26-12 12:39:49 PM

Page 1

Work Order ID: 83809

83809

Parent Item: D4095-041

D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA | | Purchased | No | | | 100 | sf | 116.8720 | 2.275 | 19.15789 | 20.5 | | |

M304S16GA

304/316 Sheet .063

**

B12-5-1

Location

Loc Qty

Loc Code

MAT020

116.872

120866

16.246

120877

100.626

120877

9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | | |
|-------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 83809 |
| Description: Wearplate | | Part Number: | D4095-1 |
| Inspection Dwg: D4095 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.19 | +0.005/-0.001 | .189 | L | | V BCZ | |
| 0.300 | +/-0.010 | .300 | 2 | | V | |
| 0.300 | +/-0.010 | .301 | 2 | | V | |
| 2.432 | +/-0.010 | 2.440 | 2 | | V | |
| 3.227 | +/-0.010 | 3.228 | 2 | | V | |
| 4.06 | +/-0.030 | 4.059 | L | | V | |
| 4.98 | +/-0.030 | 4.985 | 2 | | V | |
| 8.43 | +/-0.030 | 8.416 | L | | PROW SUR | |
| 9.22 | +/-0.030 | 9.22 | 2 | | T BC1 | |
| 3.500 | +/-0.010 | 3.500 | 2 | | T | |
| 24.750 | +/-0.010 | 24.750 | 1 | | T | |
| 11.50 | +/-0.030 | 11.50 | 1 | | T | |
| 11.472 | +/-0.010 | 11.472 | 1 | | T | |
| 6.000 | +/-0.010 | 6.00 | 2 | | T | |
| 12.104 | +/-0.010 | 12.104 | L | | T | |
| 18.000 | +/-0.010 | 18.00 | 1 | | T | |
| 30.000 | +/-0.010 | 30.00 | L | | T | |
| 9.00 | +/-0.030 | 9.00 | 1 | | T | |
| 36.000 | +/-0.010 | 36.00 | 2 | | T | |
| 38.87 | +/-0.030 | 38.87 | 2 | | T | |
| 2.50 | +/-0.030 | 2.50 | 2 | | V | |
| 0.063 | +/-0.010 | .061 | 2 | | V | |
| | | | | | | |
| | | | | | | |

| | | |
|------------------------|----------------------|------------------------------|
| Measured by: RB | Audited by: S | Preliminary Approval: |
| Date: 12-5-1 | Date: 12/6/01 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 11.02.18 | New Issue P/O D4095-041 | KJ | |
| B | 11.11.08 | Dimensions updated per Dwg Rev B | KJ | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

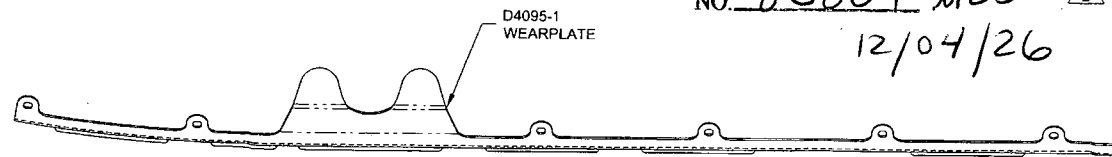
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

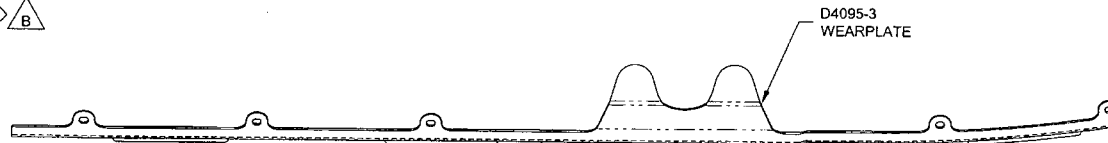
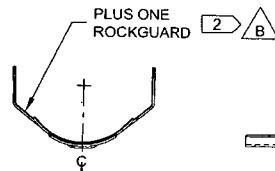
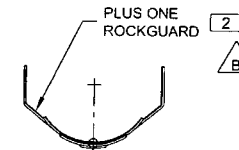
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83809 MLJ B
12/04/26

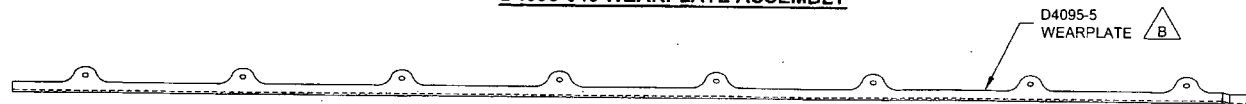
| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------------------------------|
| 1 | X | | | | | | D4095-041 | WEARPLATE ASSEMBLY |
| 2 | | X | | | | | D4095-043 | WEARPLATE ASSEMBLY |
| 3 | | | X | | | | D4095-045 | WEARPLATE ASSEMBLY |
| 4 | | | | X | | | D4095-047 | WEARPAD ASSEMBLY |
| 5 | | | | | X | | D4095-049 | WEARPAD ASSEMBLY |
| 6 | | | | | | X | D4095-051 | WEARPAD ASSEMBLY |
| 7 | 1 | | | | | | D4095-1 | WEARPLATE |
| 8 | | 1 | | | | | D4095-3 | WEARPLATE |
| 9 | | | 1 | | | | D4095-5 | WEARPLATE |
| 10 | | | | 1 | | | D4095-7 | WEARPAD |
| 11 | | | | | 1 | | D4095-9 | WEARPAD |
| 12 | | | | | | 1 | D4095-11 | WEARPAD |
| 13 | A/R | A/R | A/R | A/R | A/R | A/R | 4715 (4714) | PLUS ONE ROCKGUARD BLACK (TAN) |



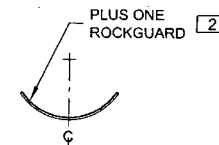
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C



| | | | |
|------------|---|---|--------------|
| B | REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2 | XDF | 11.10.18 |
| A | NEW ISSUE | MB | 10.04.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4095 | SHEET 1 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | WEARPLATE | NTS |
| DATE | 11.10.18 | <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

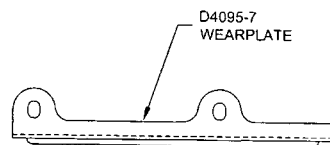
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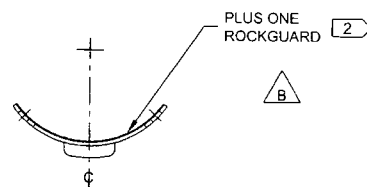
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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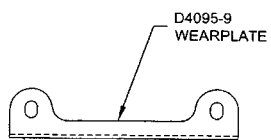
NOTE: Date & initial all entries



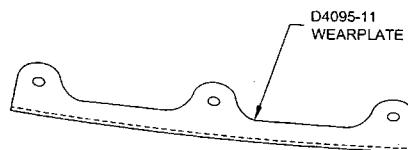
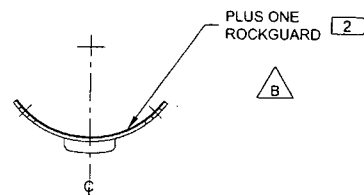
D4095-047 WEAR PAD ASSEMBLY



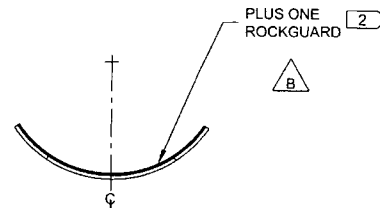
93809



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



RELEASED
2011-10-31

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | 10 | DRAWING NO. | REV. B |
| MFG. APPR. | 10 | D4095 | SHEET 2 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | WEARPLATE | NTS |
| DATE | 11.10.18 | <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

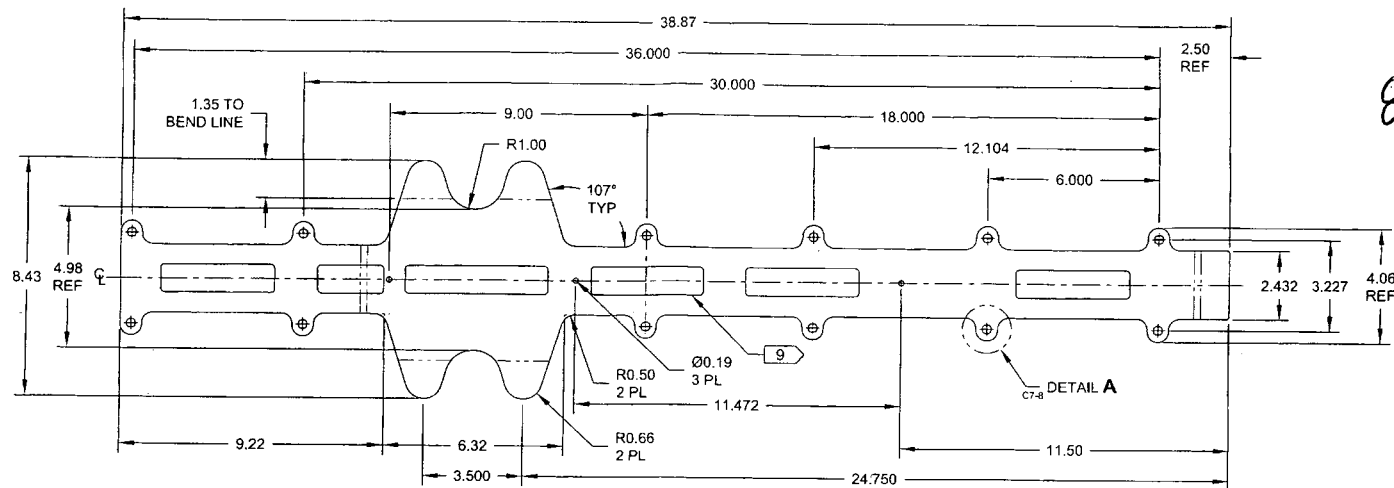
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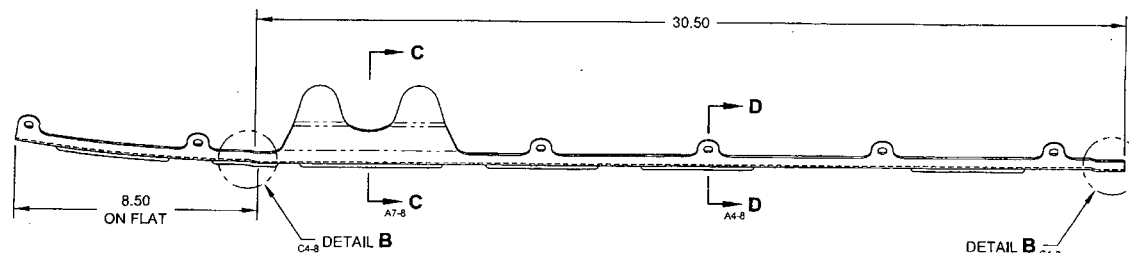
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NOTE: Date & initial all entries



D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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|------------|----------|---|--------------|
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| DRAWN | XDF | KENT, WA | |
| CHECKED | 10 | DRAWING NO. | REV. B |
| MFG. APPR. | 10 | D4095 | SHEET 3 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | WEARPLATE | NTS |
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2011-10-31
MPT

83809

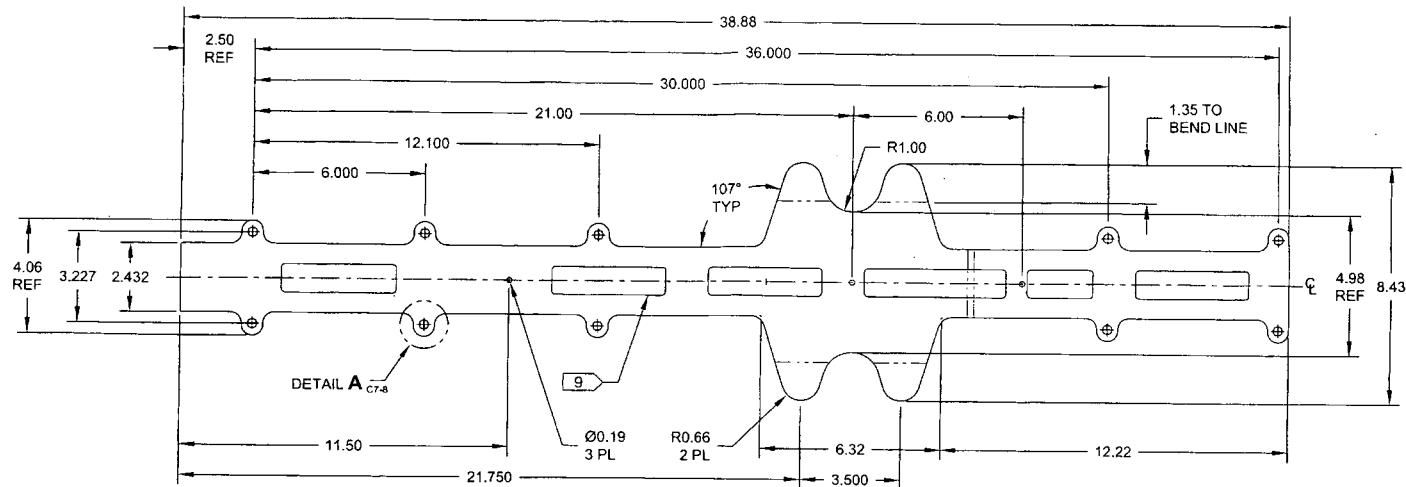
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

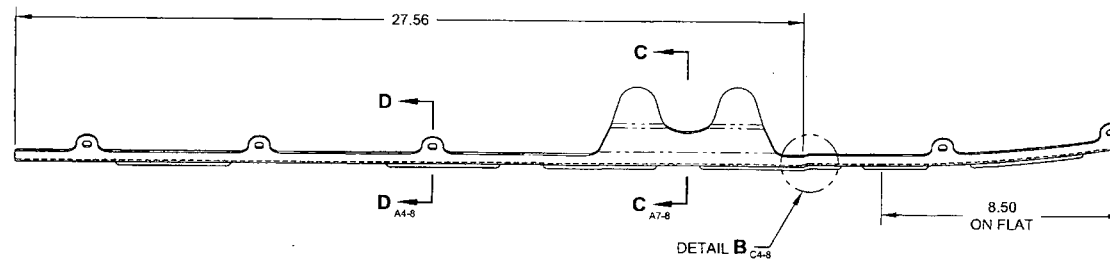
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D4095-3F FLAT PATTERN



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

83809

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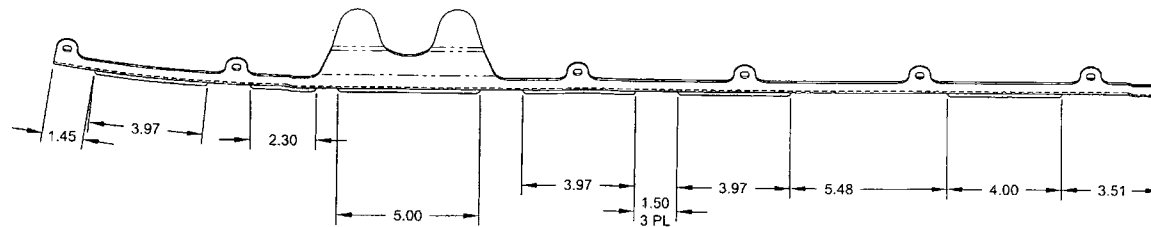
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

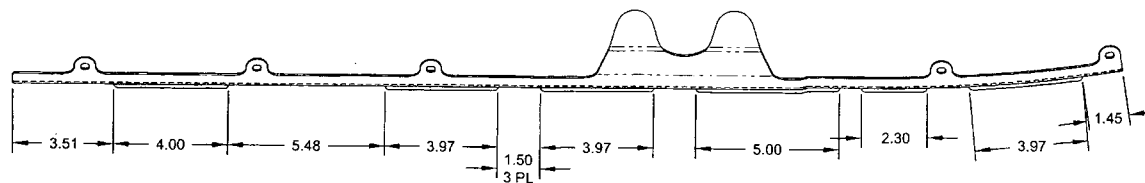
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D4095-1 WELDING DETAIL

△ B



D4095-3 WELDING DETAIL

△ B

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|------------|----------|--|--------------|
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| DRAWN | XDF | KENT, WA | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

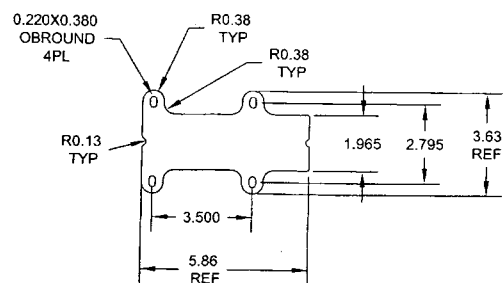
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

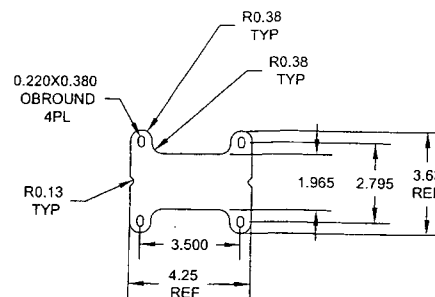
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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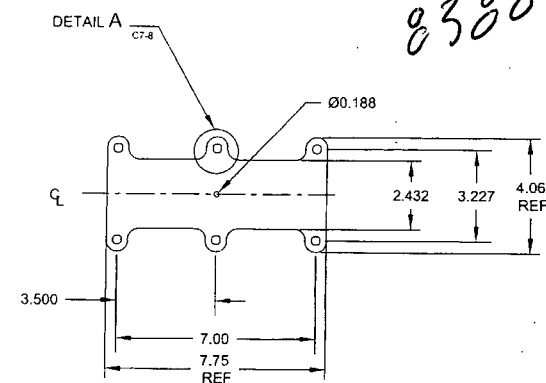
NOTE: Date & initial all entries



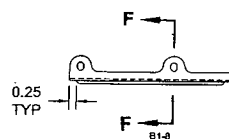
D4095-7F FLAT PATTERN 1



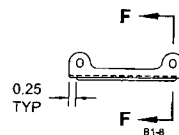
D4095-9F FLAT PATTERN 1



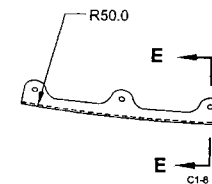
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MAKE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MAKE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

| | | | |
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| MFG. APPR. | 10 | D4095 | SHEET 7 OF 8 |
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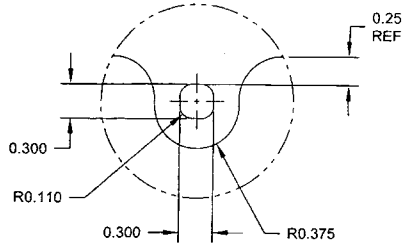
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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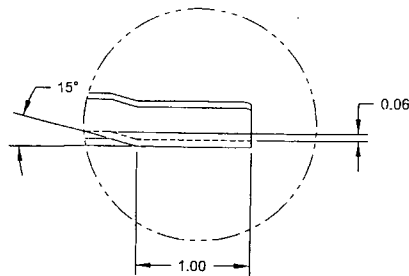
NOTE: Date & initial all entries



DETAIL A: TAB DETAIL

SCALE 4X

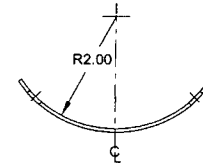
C3-3
C5-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

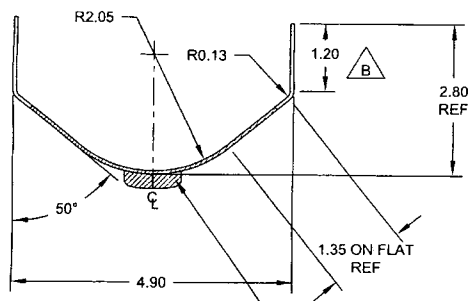
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

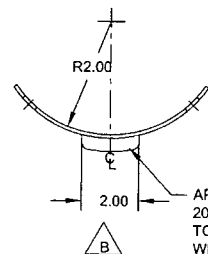


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

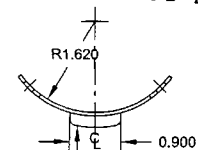


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31

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|--|--------------------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4095 | SHEET 8 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | WEARPLATE | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries